

Date: Thursday, 9/21/2006 3:12:22 PM
 User: Kim Johnston

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : OH-58 FWD X-TUBE ASSEMBLY |
| Job Number : 28675 | |
| Estimate Number : 12526 | |
| P.O. Number : | Part Number : D058676101 |
| This Issue : 9/21/2006 S.O. No. : | Drawing Number : D058-676-141 REV A2 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : LANDING GEAR | Drawing Revision : A2 |
| Previous Run : 28662 | Material : |
| Written By : | Due Date : 10/10/2006 Qty: 1 Um: Each |
| Checked & Approved By : <u>JA 06 09 21</u> | |
| Comment : Est Rev:E 06 09 11 Reformat IEC | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

1.0

DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D058-676-28675 CHG001

-101

MS 06 09 21

①
 P10

2.0

D6001105

Crosstube

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6001-105 Crosstube 23965

MS 06 09 21

1

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE

**Comment:** MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs on both ends as per Folio FA085

2-Turn first side as per Folio FA085

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D058-676-141. MS 06 09 22 1

4.0

QC1

INSPECT ALL DIM TO DIM SHEET

**Comment:** INSPECT ALL DIM TO DIM SHEET

MS 06 09 22 1

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | | |
|----------|------|------------------------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| 06/10/19 | 1.0 | - 101 not 201. please make change. | | | | | 06/10/19 | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/10/23
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 FWD X-TUBE ASSEMBLY

Job Number: 28675

Part Number: D058676101

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA085

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D058-676-141. *MS 06/09/22 1*

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

MS 06/09/22 1

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S.G 06/09/25 1

8.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Polish entire outside surface of crosstube

** Done At. Seq. 13 PM '06-9-26(1)*

2-Remove sand and plugs

3-Scribe part # and batch # using vibrating stylus as per Dwg D058-676-141

Inside of Cuff (Do not engrave on outside of tube)

MS 06/09/26 ①

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS 06/10/02

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 6-10-3

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D058-676-241 using CNC bender program OH58-fw and Folio FT014

DP 6-10-3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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QA: N/C Closed: _____ Date: _____

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Drawing Name: OH-58 FWD X-TUBE ASSEMBLY

Job Number: 28675

Part Number: D058676101

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC6

DIMENSIONAL CHECK



Comment: Inspect dimensions and work To Current Step

Jul 10 04

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D058-676-141 using drill Jig DT8541 & DT8542

2-Ream hole to finish size in tube as per Dwg D058-676-141 using drill Jig DT8541 & DT8542. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & inspect for surface damage. Repair damage within limits as per Dwg D058-676-141

IT 06-10-04

IT 06-10-04

14.0

HAND FINISHING 1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FC 06 10 05

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Jul 16 05

16.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI-0380

Issue P/O: *2186*

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

C206110105

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

C206110110

18.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D058-676-241

Jul 16 12

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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 QA: N/C Closed: _____ Date: _____

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Drawing Name: OH-58 FWD X-TUBE ASSEMBLY

Job Number: 28675

Part Number: D058676101

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI.005 4.2

08 10 13

(1)

MA

06 10 14

(1)

20.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

06-10-16 (1)

21.0

D2856400

Abrasion Strip



Comment: Qty.: 0.5800 f(s)/Unit Total : 0.5800 f(s)

Pick:

Qty Part number

Description

Batch

2 D2856-400-694

Abrasion Strip

B28258

RT

06-10-18

22.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description

Batch

2 D2891-1

Support

B28017

IT

06-10-18

23.0

MS2192020

Clamp (per-MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number

Description

Batch

4 MS21920-20

Clamp

M19936

RT

06-10-18

24.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579

2-Install supports and clamps as per Dwg D058-676-141. Torque clamps to 80-100 in lb.

IT 06-10-18 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Drawing Name: OH-58 FWD X-TUBE ASSEMBLY

Job Number: 28675

Part Number: D058676101

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-10-19 (1)

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

27.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

4 AN5-32A

Bolt

M102238 ✓

28.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

8 AN960JD516

Washer

M101369 ✓

29.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

4 MS21042L5

Nut (or -5)

M101648 ✓

DB 06/10/20

30.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/10/20 (1)

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D058-676-101

Location:

Rev B

DB 06/10/20 (1)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: OH-58 FWD X-TUBE ASSEMBLY

Job Number: 28675

Part Number: D058676101

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

06/10/08

Job Completion



U 06-10-20

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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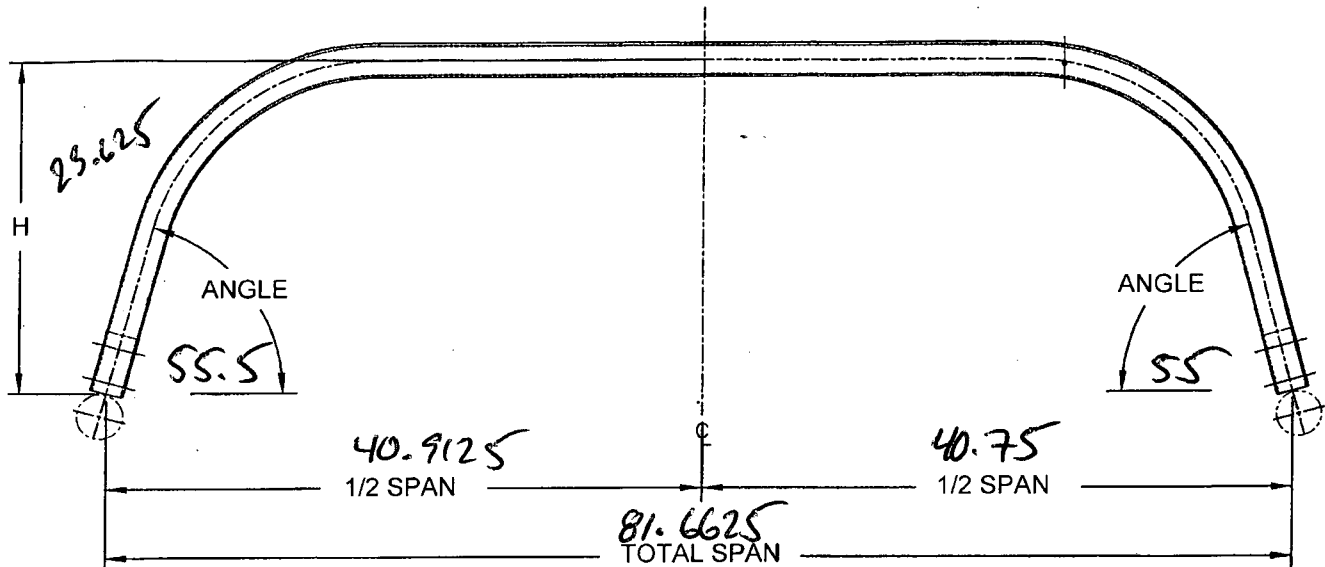
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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| | | | | | | | | |

NOTE: Date & initial all entries

Crosstube Bend Dimension Sheet



Fits table fig A1 2

DESCRIPTION: 058-676-101

BATCH NUMBER: 28675

DRAWING: -141 REVISION: A

H: 23.56 } $\pm .06$

1/2 SPAN: 40.92

TOTAL SPAN: 81.84

ANGLE: 50 \pm 2

QC#15: [Signature]

DATE: 06.10.04

QTY: 1



| | | | |
|---------------------|-----------------------|---|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>#</i> | APPROVED <i>#</i> | DRAWING NO. D058-676-141 | REV. A SHEET 1 OF 3 |
| DATE 00.11.17 | | TITLE CROSSTUBE ASS'Y (OH-58 HIGH FWD) NTS | |
| A | 00.11.17 | NEW ISSUE | |

| Qty | Part Number | Description |
|-----|---------------|-------------------------------------|
| X | D058-676-141 | CROSSTUBE ASSEMBLY (OH-58 HIGH FWD) |
| 1 | D6001-105 | CROSSTUBE |
| 2 | D2856-400-694 | ABRASION STRIP |
| 2 | D2891-1 | SUPPORT |
| 4 | MS21920-20 | CLAMP |

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6001-105
FINISHED LENGTH = 103.03±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28675

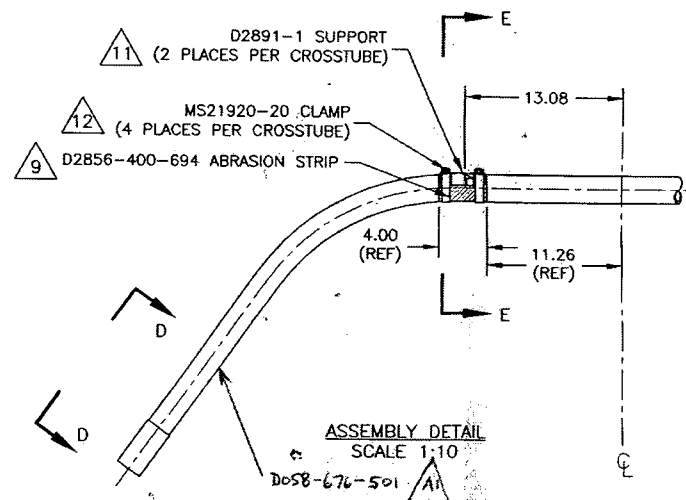
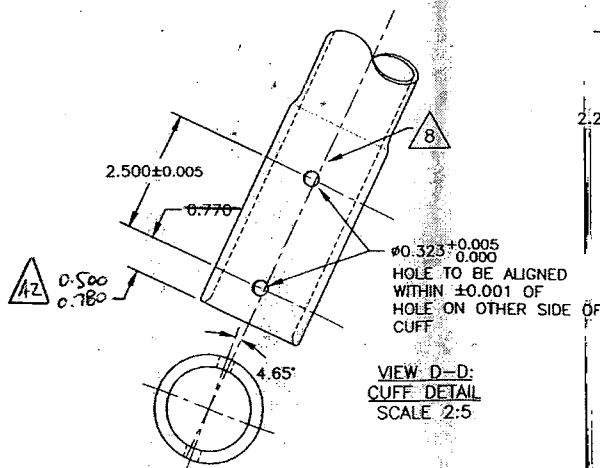
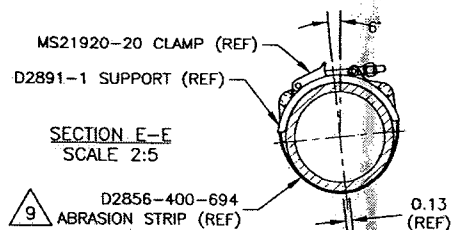
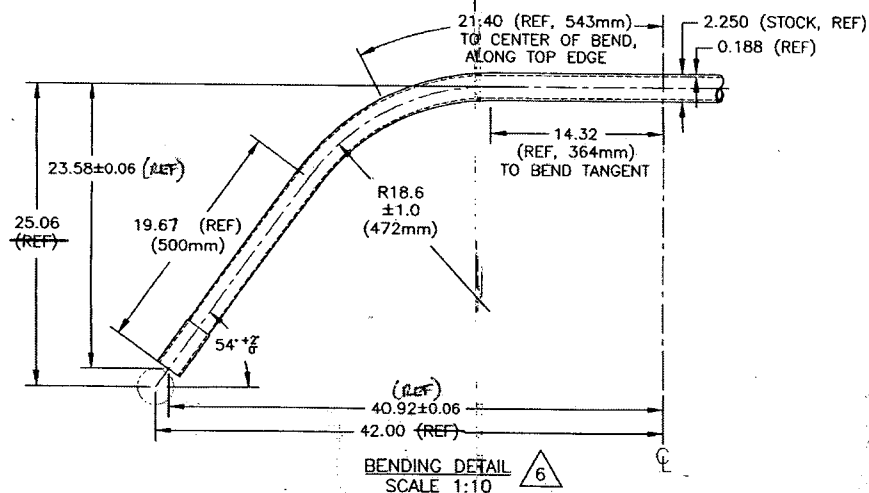
RELEASED
00.11.24 *#*

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|----|----------|--------------------------|-------------|
| A2 | 01.07.16 | UPDATE DIM TO FIRST HOLE | <i># CP</i> |
| A1 | 01.03.07 | ADD D058-676-501 P/N | <i># CP</i> |

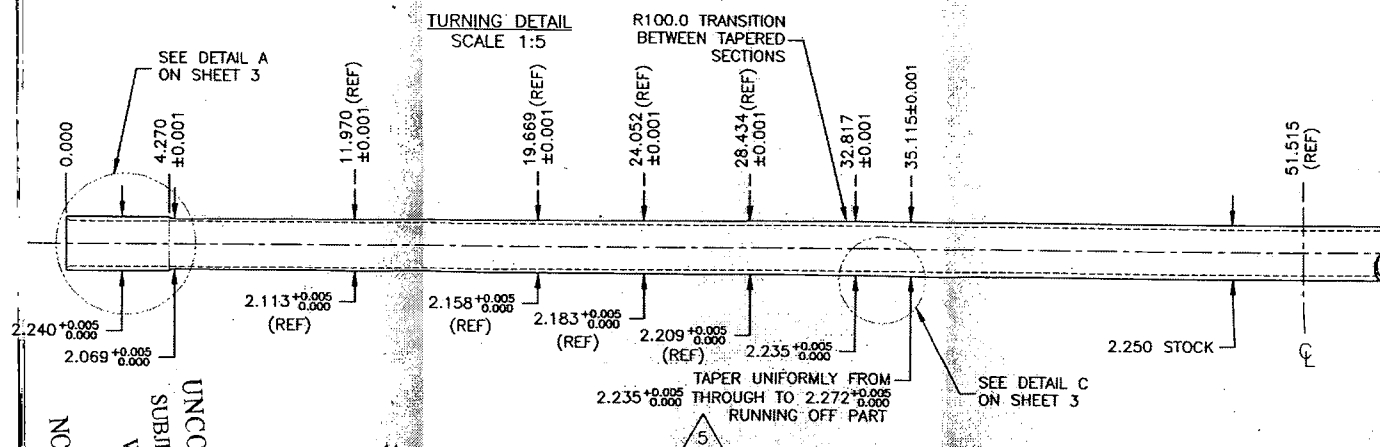
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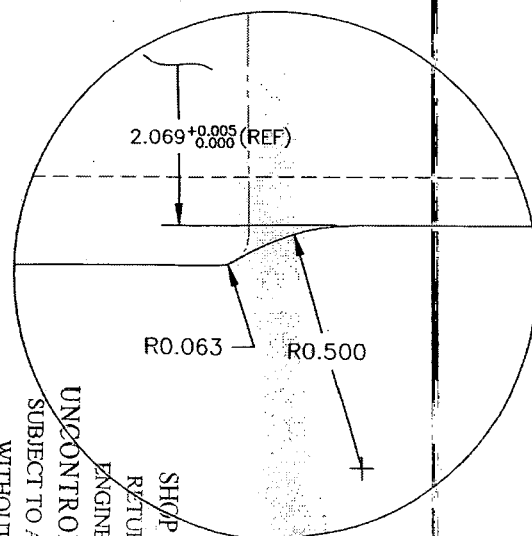
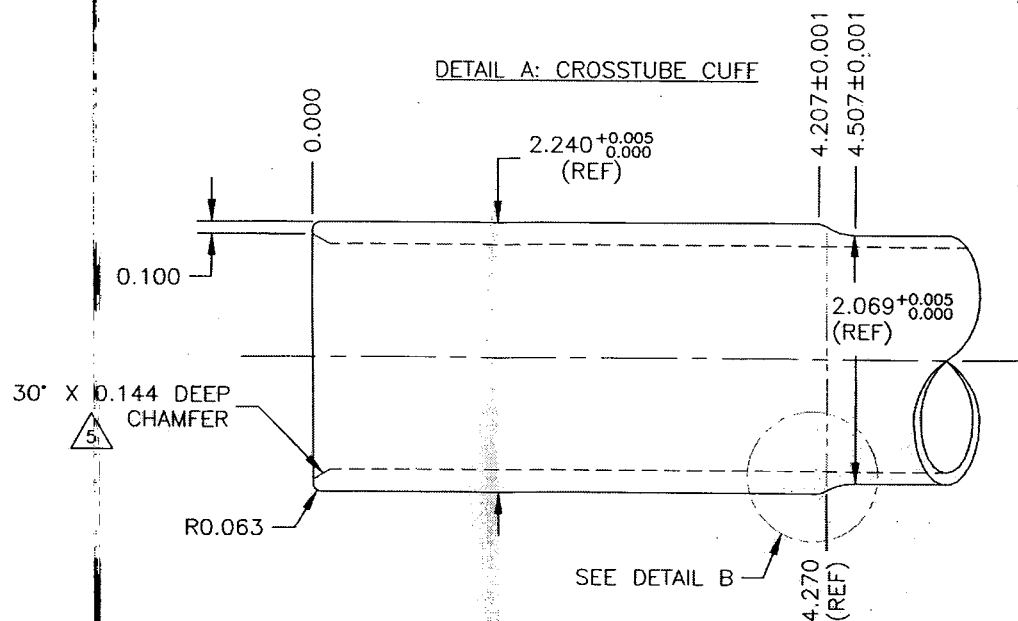


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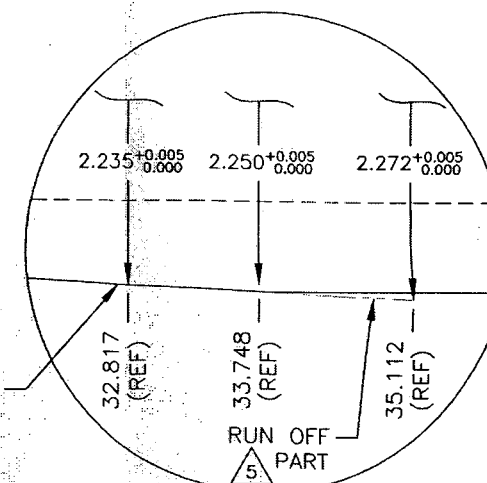
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| DATE 00.11.17 | | DRAWING NO. D058-676-141 | | TITLE CROSSTUBE ASSEMBLY (OH-58 HIGH FWD) | 1:10 |
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RELEASED
00.11.24



DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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| DATE | | 00.11.17 | DRAWING NO. D058-676-141 | |
| TITLE | | CROSSTUBE ASSEMBLY (C.H. 53 HIGH PWD.) | | |
| SCALE | | 1:1 | | |

REV. A
SHEET 3 OF 3

| | | |
|---|--|-----------------------------------|
| DART AEROSPACE LTD | | Work Order: 28675 |
| Description: Crosstube assembly | | Part Number: DOH58-616-141 |
| Inspection Dwg: DOH58-616-141 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

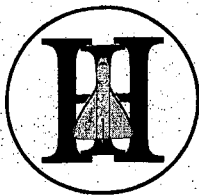
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------------|------------------|--------|--------|----------------------|----------|
| 4.207 | ±.001 | 4.207 | ✓ | | | |
| .100 | ±.010 | .100 | ✓ | | | |
| .063 | ±.010 | .063 | ✓ | | | |
| 2.240 | ±.005 - .000 | 2.245 | ✓ | | | |
| 2.069 | " | 2.073 | ✓ | | | |
| 2.113 | " | 2.117 | ✓ | | | |
| 2.158 | " | 2.162 | ✓ | | | |
| 2.183 | " | 2.188 | ✓ | | | |
| 2.209 | " | 2.213 | ✓ | | | |
| 2.235 | " | 2.239 | ✓ | | | |
| 4.207 | ±.001 | 4.207 | ✓ | | | |
| .100 | ±.010 | .100 | ✓ | | | |
| .063 | ±.010 | .063 | ✓ | | | |
| 2.240 | ±.005 - .000 | 2.244 | ✓ | | | |
| 2.069 | " | 2.073 | ✓ | | | |
| 2.113 | " | 2.117 | ✓ | | | |
| 2.158 | " | 2.163 | ✓ | | | |
| 2.183 | " | 2.187 | ✓ | | | |
| 2.209 | " | 2.213 | ✓ | | | |
| 2.235 | " | 2.240 | ✓ | | | |
| 103.03 | ±.020 | 103.03 | ✓ | | | |

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|------------------------|
| Measured by: MB |
| Date: 06/09/22 |

| |
|------------------------|
| Audited by: J.G |
| Date: 06/09/25 |

| |
|----------------------------|
| Prototype Approval: |
| Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 34996

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of six (6) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (4) P/N D058-676-101 S/N's B28676, B28675, B28660 & B28467

Qty. (2) P/N D058-676-201 S/N's B28768 & B28765

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on six (6) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)

Ardrox 970P25E Batch #04B503.

Six (6) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: 

DATE October 6, 2006

INSPECTION STAMP(S) Not Required

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER 00002186

ADDRESS:

CONTACT NAME:

| | | |
|-----------------|---|-----|
| LABOUR | @ | \$ |
| MATERIALS | @ | |
| TRAVEL EXPENSES | @ | GST |
| HOTEL EXPENSES | @ | PST |

INVOICE NO.

TOTAL \$